

Work Order ID 87147 - 1

July-11-12 8:57:09 AM

Spl. 7 - 2

87147

Page 1

Item ID: D3884-1

Revision ID:

Item Name: Saddle, Inboard LH

Start Date: 7/11/12

Start Qty: 5.00

5

Required Date: 7/17/12

Req'd Qty: 5.00

5

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 12-07-12 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3884

B

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 87147

Double check by: SA

1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets

SL 12-08-04

3

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

SL 12-08-04

3

4

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Item ID: D3884-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Inboard LH

Stop *NS2*

Start Date: 7/11/12 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 7/17/12 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		B.a 12/08/07		3	0		
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				3		12.88	
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8h55 OVEN TEMPERATURE: 320°F FINISH TIME: 9h25	0.00 0.00		miz 481		3	20	12/08/09	

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Item ID: D3884-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, Inboard LH

Stop ***NS2***

Start Date: 7/11/12

Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/17/12

Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

3x 1 11/10/12

160

Identify as per dwg & Stock Location: 54

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

44/8/9 B

12/8/10

12/20/9

Picklist Print

July-11-12 8:57:09 AM

Page 1

Work Order ID: 87147

Parent Item: D3884-1

Parent Item Name: Saddle, Inboard LH

Start Date: 7/11/12

Required Date: 7/17/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017 Saddle Billet		Manufactured	No				Each	4.0000					

5
12/08/07

Location

Loc Qty

Loc Code

MAT047

4

→ 74801

4

4.0

DART AEROSPACE LTD		Work Order:	87147
Description: Saddle, Inboard, LH		Part Number:	D3884-1
Inspection Dwg: D3884	Rev. B	Page 1 of 1	

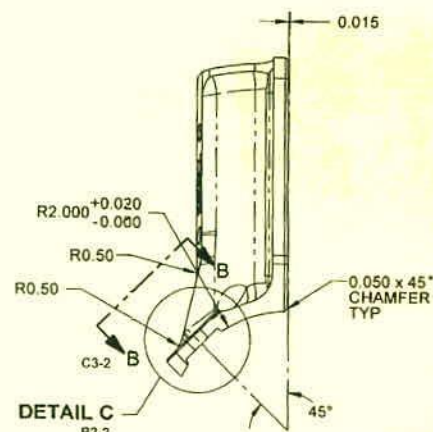
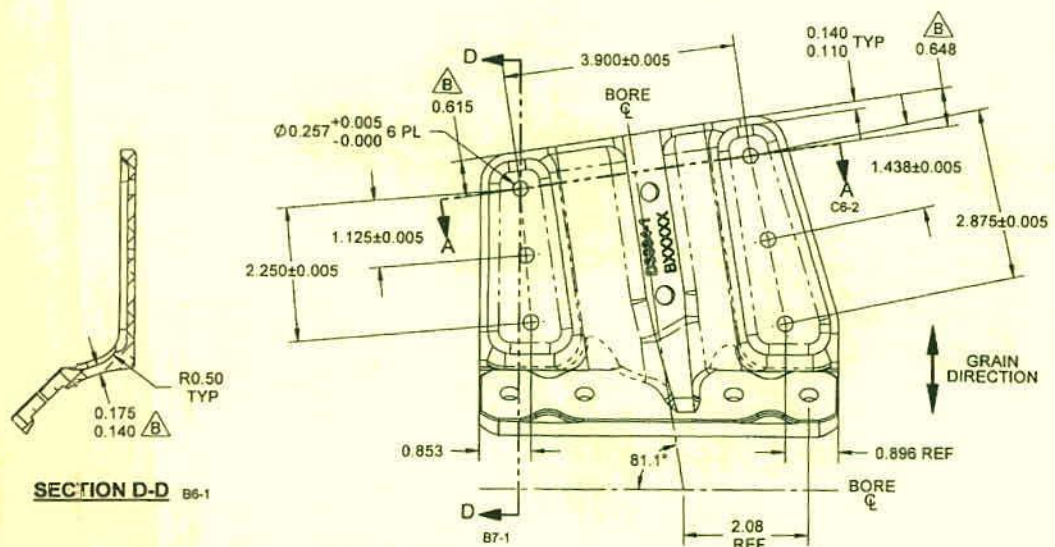
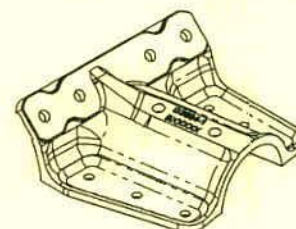
Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		0.649	0.649	0.649	0.649		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		0.258	0.258	0.258	0.258		
F	0.605	0.625		0.617	0.615	0.615	0.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.004	2.002	2.001	2.005		
J	0.140	0.175		0.150	0.151	0.151	0.151		
K	1.265	1.285		1.269	1.267	1.266	1.260		
L	0.115	0.135		0.126	0.125	0.125	0.125		
M	0.240	0.260		0.252	0.252	0.252	0.251		
N	0.110	0.140		0.135	0.135	0.135	0.135		
O	0.240	0.260		0.254	0.250	0.251	0.249		
P	2.826	2.886		2.868	2.868	2.868	2.868		
Q	0.178	0.198		0.188	0.188	0.188	0.188		
R	0.140	0.165		0.155	0.152	0.153	0.152		
S	0.720	0.780		0.760	0.760	0.760	0.760		
T	1.220	1.280		1.255	1.255	1.255	1.255		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.003	6.003	6.003	6.003		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		0.501	0.501	0.500	0.500		
Y	0.020	0.040		0.030	0.030	0.030	0.030		
Z	0.313	0.318		0.314	0.314	0.314	0.314		
AA	0.760	0.765		0.761	0.761	0.761	0.761		
AB	0.215	0.220		0.208	0.218	0.218	0.220		
AC	0.316	0.321		0.316	0.316	0.316	0.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.010	1.000	1.000	1.000		
AF									
Accept/Reject									

Measured by: <u>Y</u>	Audited by: <u>HA</u>
Date: <u>12-08-04</u>	Date: <u>12/08/07</u>

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

87147
R100712



SECTION D-D B6-1

D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)

RELEASED
01/07/15/14

- NOTES:
- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
 - 7) WEIGHT: 0.71 lbs.

B	D6101-017 WAS D6102-017, ZN A6-1; ADD NOTE, ZN C4-2; ADD R0.031, ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165, ZN B7-1; ADD 0.615, ZN C6-1; ADD 0.648, ZN C4-1; ADD 0.250, ZN D6-2; ADD 0.080, ZN C2-2; 0.75 WAS 0.65, ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3884**

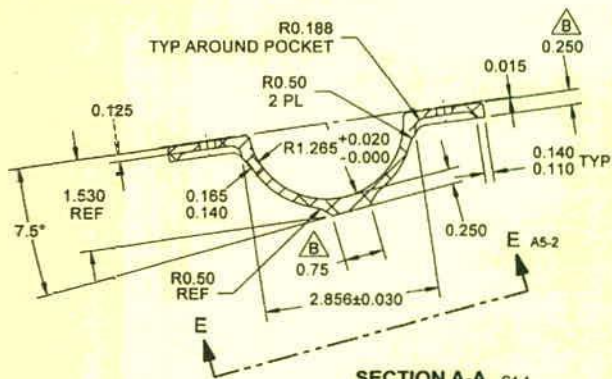
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SCALE **NTS**

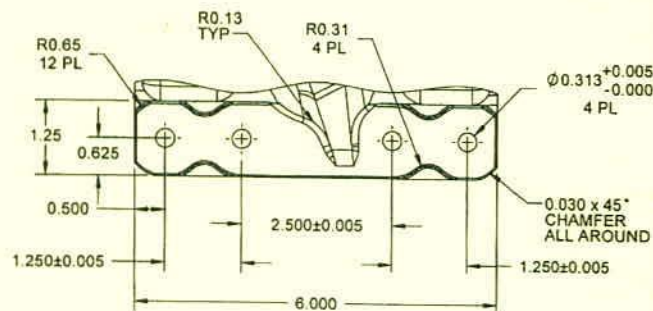
REV. B
SHEET 1 OF 2

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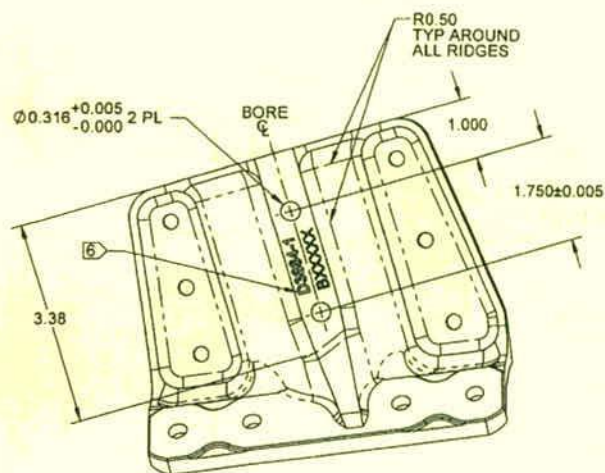
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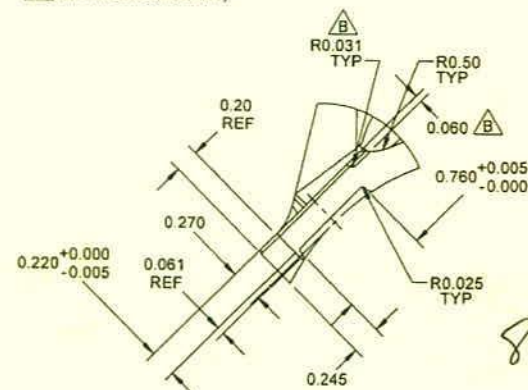
SECTION A-A C4-1



VIEW B-B B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

RELEASED
09/15/10

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	PH	DRAWING NO. D3884	REV. B
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
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